

**Work Order ID 72346**

Friday, July 22, 2011 2:46:31 PM



Page 1

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*HF*

Date:

*11-07-22*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D139-799

D

0.00

0.00

0.00

0.00

0.00

0.00

100



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-013  
CHG002*8/11/06**HF dar MLS 11-9-30*

110



Packaging

Packaging

Pick Kit

Memo

*11/9/30 JFC*

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

*8/11/06**(76)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72346**

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Page 2

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D139-799-013

Location: 50PPP rev: A11/10/11 6.00

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/10/11 MFMF  
11-10-67

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 22, 2011 2:46:37 PM

Page 1

Work Order ID: 72346

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge



Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM  
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2585		Manufactured	No			110	Each	61.0000	1	6			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Mounting Channel

Location

Loc Qty

Loc Code

ST017

61

69536

5

70814

56

D2586		Manufactured	No			110	Each	84.0000	1	6			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Door Latch

Location

Loc Qty

Loc Code

ST204

84

64774

34

70557

50

D2621		Manufactured	No			110	Each	28.0000	1	6			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Latch Plate, 350 Spacepod

Location

Loc Qty

Loc Code

ST019

28

56526

28

D3552-13		Manufactured	No			110	Each	7.0000	1	6			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Door Prop

Location

Loc Qty

Loc Code

ST272A

7

69668

7

373297

B73296 11/10/15

6

B72101 11/10/15

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, July 22, 2011 2:46:37 PM

Work Order ID: 72346

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

D3622-1

Manufactured No

110

Each

24.0000

1



Ball Stud

LocationLoc QtyLoc Code

ST070

24

67284

3

~~71540~~

21

110

Each

38.0000

1

D3622-3

Manufactured No



Ball Stud

LocationLoc QtyLoc Code

ST070

38

53951

38

110

Each

20.0000

2

D4072-1

Manufactured No



Airframe Hinge

LocationLoc QtyLoc Code

ST121

20

71535

20

110

Each

16.0000

2

D4072-3

Manufactured No



Airframe Hinge Backing Plate

LocationLoc QtyLoc Code

ST119

16

71536

16

110

Each

11.0000

4

D4072-5

Manufactured No



Bushing

LocationLoc QtyLoc Code

ST119

11

71537

11

Friday, July 22, 2011 2:46:38 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, July 22, 2011 2:46:38 PM

Work Order ID: 72346

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

D4073-1 Manufactured No

110 Each

20.0000

2

12



Door Hinge



B7A242

Location

Loc Qty

Loc Code

ST120

20

71539

20

D4073-3 Manufactured No

110 Each

14.0000

2

12



Door Hinge Backing Plate



B72108

Location

Loc Qty

Loc Code

ST120

14

71541

14

D4074-1 Manufactured No

110 Each

12.0000

1

6



Bracket



B72109

Location

Loc Qty

Loc Code

ST122

12

71542

12

D4074-3 Manufactured No

110 Each

15.0000

1

6



Channel



B72111 11/10/38 B72110 (2x) B72403 (4x)

Location

Loc Qty

Loc Code

ST120

15

71543

15

D4074-5 Manufactured No

110 Each

15.0000

1

6



Backing Plate



B72111 11/10/38 (6)

Location

Loc Qty

Loc Code

ST122

15

71544

15

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72346

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

D4074-7

Manufactured No

110

Each

17.0000

1

6



Striker Plate



376112

374496

## Location

## Loc Qty

## Loc Code

ST120

17

71546

17

Purchased

No

110

Each

1,430.000

20

120

MS21042L3



Nut



## Location

## Loc Qty

## Loc Code

ST300

1430

117441

670

117601

400

117885

360

Purchased

No

110

Each

1,320.000

1

6

MS21042L5



Nut



## Location

## Loc Qty

## Loc Code

ST300

1320

116105

5

116548

131

117441

498

117591

100

117611

90

118179

496

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72346

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

MS27039-1-10 Purchased

No

110

Each

155.0000

8



Screw

Location

Loc Qty

Loc Code

ST290

150

117441

150

ST291

5

115935

5

MS27039-1-14 Purchased

No

110

Each

132.0000

2



Screw

Location

Loc Qty

Loc Code

MEZZ

132

112312

100

15924

32

MS27039-1-16 Purchased

No

Each

168.0000

48



Screw

Location

Loc Qty

Loc Code

ST292

168

118384

168

MS27039-1-17 Purchased

No

110

Each

118.0000

1



Screw

Location

Loc Qty

Loc Code

ST292

118

11540

18

117591

100

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72346

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

110

Each

2,796.000

18



Washer



108

Location

Loc Qty

Loc Code

ST298

2796

117505

426

117601

370

118077

2000

108

NAS1149D0663J

Purchased

No

110

Each

991.0000

1



Washer



6

11/9/30

Location

Loc Qty

Loc Code

ST298

991

115996

5

117291

86

117977

500

118378

400

6

NAS1515H5L

Purchased

No

110

Each

128.0000

4



WASHER



24

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

88

111359

5

118378

83

28

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-13	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

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